Work Order	ID	73	338
Wednesday, August	t 31.	2011	11.0



Wednesday, Aug	ust 31, 2011 11:04:23 AM										Page 1
Revision ID:	D3405-041 Lug Assembly		Accept				iii s	Setup S	Start Stop		
	9/1/2011 Start Qty: 12.00			Cust Item Customer:							
Approvals:	Process Plan: MF QC:	Date:] -09-0	Yes Tooling: SPC (Y/N):		Oate:		F		Start Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								****		
D3405	Rev B										
Waterjet FLOW CNC Waterjet 304.175	FLOW WATER JET Memo 1-Cut as per Dwg Rev: Prog Rev: 2-Deburr if r	Dwg D3405 necessary	0.00				- TUI-	9- 8)	
QC Quality Control	QC2- Inspect parts off m Memo	achine FAI/FAIB	0.00				BI	- <u>5-8</u>	<u> </u>	<u> </u>	
120 QC Quality Control	QC8- Inspect parts - seco	and check	0.00	lorlog			B	<u> </u>			<u> </u>

Dart Aerospace	Ltd
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W/O:			WO	RK ORDER CHANG	ES			-	•
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	Jory:	NCR: Yes	No DQ	4:	Date: _	
	R	esolution:	Disposition	:	_ QA: N/C CI	osed:		Date: _	
NCR:		1	WORK ORDE	ER NON-CONFORMA	NCE (NCF	1)	•		
DATE	OTED	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	- Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector
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Work Order ID 73338

Wednesday, August 31, 2011 11:04:23 AM



Page 2

Item ID:

D3405-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Lug Assembly

Start Date:

9/1/2011

Start Qty: 12.00 Req'd Qty: 12.00

Customer:

Cust Item ID:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Qty

Start

Stop



Required Date: 9/15/2011

Date: _____

SPC (Y/N):

0.00

0.00

Set Up/

Run Hours

Date:

Tool # Plan

Code

Accept Reject

Reject

Insp. Number Stamp

Work Center ID 130

Sequence ID/

Brake NC

Brake NC

NC BRAKE

Operation

Description

Memo 1-Deburr

Memo

2-Form using DT8204 as per Dwg D3405

3- use DT9681 to check if correct forming

So ul09/13

....

Qty

140

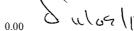
QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00



150

Large Fab

Large Fab

Large Fab

Memo

Identify as D3405-041

Weld as per Dwg D3405 use DT8484

A 149-13

W/O:			W	ORK ORDER CHANG	ES	·			
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _	
	Re	esolution:	Dispositi	on:	_ QA: N/C C	losed:		Date: _	
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DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
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Work Order ID 73338



Page 3

Wednesday, August 31, 2011 11:04:23 AM

Item ID:

D3405-041

Revision ID:

Item Name:

Lug Assembly

Start Date:

9/1/2011

Start Qty: 12.00

Accept

Run

Setup Start



Stop

Required Date: 9/15/2011

Req'd Qty: 12.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: ____ QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start

Stop

Sequence ID/

Work Center ID

160

Quality Control

Operation Description

QC9- Inspect visual per QSI004- Fusion Welds

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty**

Reject Number

Insp. Stamp

Cpl 11.09.13

170

180

OC

Quality Control

QC5- Inspect part completeness to step on W/O

1,4 "

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Powdercoat

Powder Coating

W118439

Memo

START TIME: OVEN TEMPERATURE FINISH TIME:

15x 6 mf 11/04/15

W/O:			WO	RK ORDER CHANG	ES				,
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #:	Fault Categ	jory:	NCR: Yes	No D Q	A:	_ Date: _	
	Re	esolution:	Disposition	ı:	_ QA: N/C Ck	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR)	-		
DATE	STEP	Description of NC	<u> </u>		ion B		cation	Approval	Approval
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Work Order ID 73338

Wednesday, August 31, 2011 11:04:23 AM



Page 4

Item ID:

D3405-041

Accept

Tool # Plan

Code

Setup Start



Revision ID:

Item Name: **Start Date:**

Lug Assembly

9/1/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 9/15/2011

Process Plan:

Date:

Date:

Tooling:

Date:

Start Run

Stop

Stop

SPC (Y/N):

Set Up/

Date:

Tool ID

Sequence ID/

Work Center ID

190

Quality Control

Operation **Description**

QC:

QC3- Inspect Part Finish

Run Hours

0.00

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Memo

0.00

BD 11-9-15

200

Packaging Packaging

Identify as per dwg & Stock Location: 7

0.00

Memo

0.00

210

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF (1-09-16

Dail Ac	Ospace	- Lu							
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PROC	EDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	R	esolution:						Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	OTED	Description of NC		Corrective Action Secti		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector
]	

Picklist Print

Wednesday, August 31, 2011 11:04:20 AM

Work Order ID: 73338

Parent Item:

D3405-041

Parent Item Name: Lug Assembly



Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP A□05.09.01□New issue□KJ/JLM□

IPP B 09.01.28 rev B drawing EC verified by:DD

	FF B 09.01.28	rev.B drawing	LC V	ciffica by.DD									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1		Manufactured	No			100	Each	50.0000	1	12 <i>E</i> Z	11-	9-/3	
				Location		<u>Loc</u>	<u>Qty</u>	Loc Code					
				WA			7						
					70664		7				_		
				WA030			43						
				2	72326		43		_	15			
M304S11GA	201 2007 (01 100)	Purchased	No			150	sf	43.5000	0.154	1.945263	9.1	5	
304/316 0.125 Sheet											B11-9	1-8	
				Location		Loc	<u>Oty</u>	Loc Code				(X	
				MAT020			43.5				. ' <i>(</i>	(())	
					117494		43.5			17494	\	$\setminus \mathcal{I}$	

W/O:				WORK ORD	DER CHANGES					
DATE	STEP		PROC	EDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						<u></u>				
Part No):		_ PAR #:	Fault Category:	NC	R: Yes	No DQ	4 :	Date: _	
	R	lesolution:		Disposition:	QA	A: N/C (Closed:		Date: _	

	,	WORK ORD	ER NON-CONFORMANO	CE (NCR)			
	Description of NC		Corrective Action Section B		Varification	A	Annvoyal
STEP	Section A	Initial Chief Eng	Initial Action Description Sign &		Section C	Chief Eng	Approval QC Inspecto
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Corrective Action Section B Initial Action Description Sign &	STEP Description of NC Initial Action Description Sign & Section C	STEP Description of NC Corrective Action Section B Verification Approval Section A Section C Chief Eng

DART AEROSPACE LTD	Work Order:	73338
Description: GHW Lug	Part Number:	D3405-1
Inspection Dwg: D3405 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	-439	يے		VAN7	
1.50	+/-0.030	1.512	>		V '	
1.750	+/-0.010	1756	5		V	
6.751	+/-0.010	6.760	>		V	
8.00	+/-0.030	8.000			V	,
0.125	+/-0.010	رال	>		V	
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			-			
						<u> </u>
		10		<u> </u>		
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Measured by:	Audited by:	Prototype Approval:	N/A
Date: 1(-9-9)	Date: ulos/09	Date:	N/A

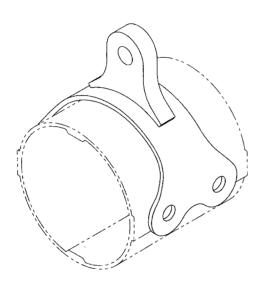
Γ	Rev	Date	Change	Revised by	Approved
-	A	08.11.28	New Issue P/O D3405-041	KJ/EC	11
	В	09.05.04	Dimensions update per Dwg Rev. B	KJ/DD 4	

Dart Ae	rospac	e Ltd
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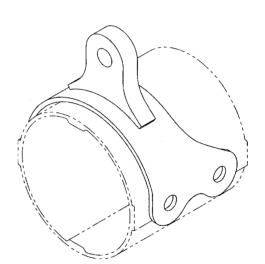
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Part No		PAR #:								
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DATE S	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector	
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ITEM No. QTY. QTY. -043 DESCRIPTION PART NUMBER D3405-041 LUG ASSEMBLY х LUG ASSEMBLY D3405-043 2 х GHW LUG 11 1 1 D3404-1 GHW BRACKET 12 1 D3405-1 GHW BRACKET 13 D3405-3





D3405-041 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)



D3405-043 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)



NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
2) IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
3) WEIGHT 041 085 lbs

7) WEIGHT: -041, 0.85 lbs -043, 0.87 lbs

8

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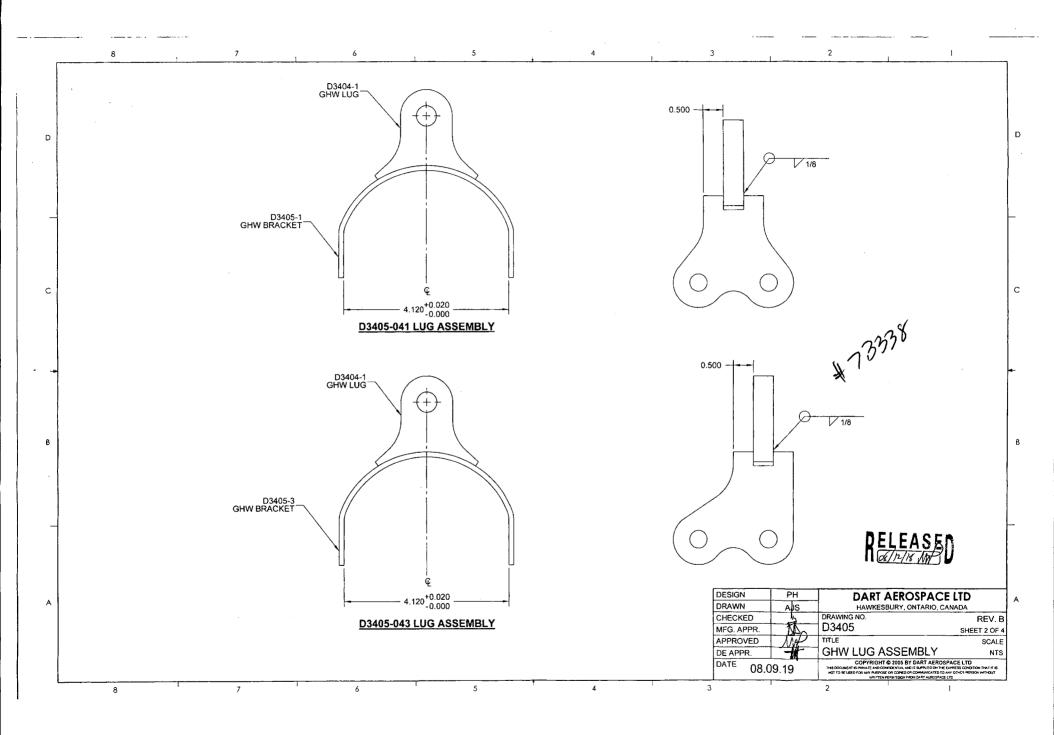
DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER FLAT PATTERNS FOR 1.6.3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198) SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100. 08.09.19 NEW ISSUE PH 05.03.08 REV. DESCRIPTION DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3405 MFG. APPR. SHEET 1 OF 4 APPROVED TITLE SCALE GHW LUG ASSEMBLY DE APPR NTS COPYRIGHT © 2005 BY DART AEROSPACE LTD

T IS PRIVATE AND COMPUBRITIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
FOR ANY PURPOSE OR COPED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT DATE 08.09.19

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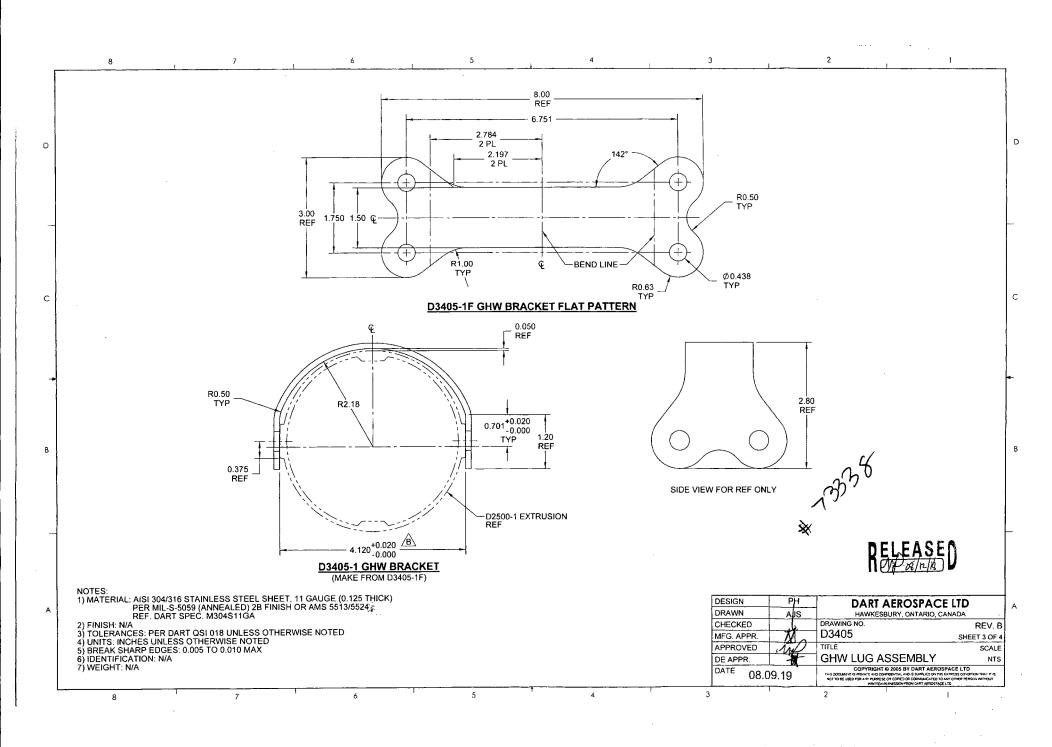
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DATE	STEP	PROC	EDURE CH	ANGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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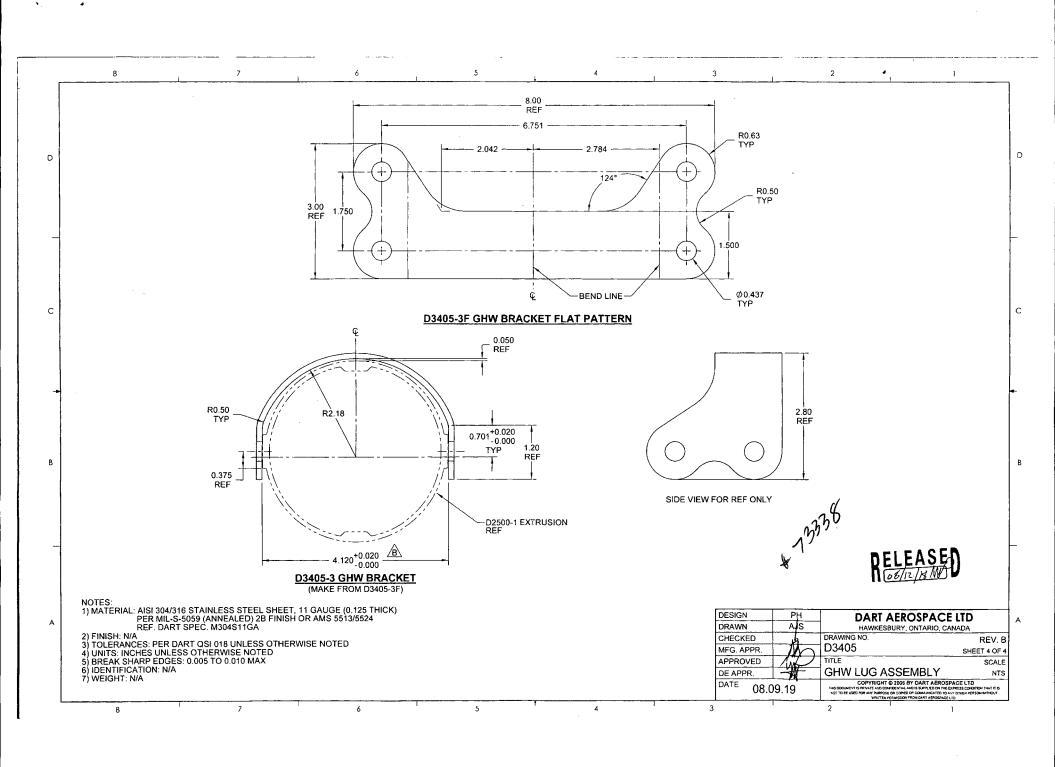


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W/O:			WORK ORDER CHANGES								
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DATE	STEP	Description of NC	Corrective Action Section B				Verific	cation	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector	